

Claims

1. Packaging container, especially packaging tube (10) with anticounterfeiting feature (15) for pasty packaging materials comprising a tube body (11) made of a flexible plastic foil or of a flexible plastic/metal laminate foil with at one end arranges thereon a non-flexible prefabricated tube head (12) of plastic material, comprising a shoulder (14) and extending therefrom a closable outlet (16), whereby the shoulder (14) is attached to the body (11) by means of a material portion (17) of plasticized and squeeze formed plastic material connecting an inner surface of one end of body (11) with an outer circumference of the shoulder (14), characterised thereby that the shoulder (14) carries an anticounterfeiting feature (15) of a different colour as that of the shoulder (14).
2. Packaging container according to claim 1, characterised thereby that the feature (15) is formed as a ring arranged upon the shoulder (14) and encircling same.
3. Packaging container according to claim 1 or 2, characterised thereby that the feature (15) is formed by part of the squeezed material portion (17).
4. Packaging container according to one of the claims 1 to 3, characterised thereby that the feature (15) has an outer (27) and an inner (28) demarcation, both encircling the head (12) upon its shoulder (14).

5. Packaging container according to one of the claims 1 to 3, characterised thereby that feature (15) is delimited by an outer running round demarcation (27) and an inner running round demarcation (28), whereby the inner running round demarcation (28) is formed by plastic material freely flowing upon shoulder (14) and displaced from portion (17) in direction of outlet (16).
6. Packaging container according to one of the claims 4 or 5, characterised thereby that the outer run around demarcation (27) is formed by a freely running round edge (26) of ring shaped section (22) of body (11) and that the inner running round demarcation (28) is formed by an in the direction of outlet (16) upward directed surface (30) of a stepped arrangement (29) arranged upon the outer surface of shoulder (14).
7. Packaging container according to one of the claims 1 to 6, characterised thereby that the annular section (22) is bent over in direction of shoulder (14) covering an annular room (35) between shoulder (14) and annular section (22)
8. Method to manufacture a packaging tube according to one of the claims 1 to 7, characterised thereby that a tube body (11) is placed upon the outer circumference of a mandrel (20) leaving an annular section (22) extending axially therefrom and that a prefabricated head (12) of first colouring is placed upon a mandrel slope (24) of mandrel (20) a material portion (17) abutting and encircling the inner surface of annular sec-

tion (22) is deposited upon an annular room (35) between head (12) and inner surface of section (22) said portion (17) of different colour than said first colouring and mandrel (20) being entered into matrix (39) bending section (20) and pressing thereby a first part of material portion (17) in direction of annular room (35) and a second part of material portion (17) between section (22) and shoulder (14) in direction of an outlet (16) and flowing a head a freely running round edge (26) of section (22) thereby connecting tube body (11) and tube head (12) and forming the anticounterfeiting feature (15).

9. Method to manufacture a packaging tube according to claim 8, characterised thereby that the feature (15) upon shoulder (14) is formed by the part of the material portion (17) flowing ahead of the annular section (22).
10. Method to manufacture a packaging tube according to claim 8 or 9, characterised thereby that the second part of material portion (17) is pressed into stepped arrangement (29).
11. Method to manufacture a packing tube according to claim 10, characterised thereby that the material portion (17) is being pressed against an upward directed surface (30) of stepped arrangement (29).
12. Method to manufacture a packaging tube according to claim 9, characterised thereby that the part of material portion (17)

flowing ahead of the annular section (22) is without forming elements freely expanding toward outlet (16).